

Claims:

1. Method for producing an embossing roller from silicone rubber for the continuous embossing of the surface of a thermoplastic film, with the embossing surface having a negative form of a surface structure to be embossed, in particular a grain, comprising:

5 a) an auxiliary roller is first produced which is made of plastic or a metallic material, at least in the region of its circumferential surface;

10 b) the circumferential surface is smooth;

15 c) a laser beam is directed onto the circumferential surface;

d) the laser beam moves relative to the circumferential surface and is controlled so as to be congruent with the particular site on the surface structure of a real pattern or of an imaginary pattern which is present in the form of data, in such a way that the surface structure of the pattern is created as a positive structure in the circumferential surface of the auxiliary roller;

20 e) a layer of silicone rubber of uniform thickness is poured or spread onto the positively structured circumferential surface of the auxiliary roller thus formed, and vulcanized to produce an embossing matrix, and

25 f) the embossing matrix is pulled from the circumferential surface of the auxiliary roller, turned inside out, and adhered to a circumferential surface of an embossing roller, with the negatively structured embossing surface facing outward.

2. Method according to Claim 1, wherein:

a) the plastic in the region of the surface of the auxiliary roller is disposed in such a way that the silicone rubber poured or spread onto this surface may be separated from the surface of the auxiliary roller after vulcanization.

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3. Method according to Claim 2, wherein:

a) the plastic is nitrile butadiene rubber (NBR).

4. Method for producing an embossing roller from silicone rubber for the continuous embossing of the surface of a thermoplastic film, with the embossing surface having a negative form of a surface structure to be embossed, in particular a grain, comprising:

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a) an auxiliary roller being provided, the auxiliary surface being smooth, at least in the region of its circumferential surface;

b) a laser beam being directed onto the circumferential surface:

c) the laser beam being moved relative to the circumferential surface and being controlled so as to be congruent with the particular site on the surface structure of a real pattern or of an imaginary pattern which is present in the form of data, in such a way that the surface structure of the pattern is created as

a positive structure in the circumferential surface of the auxiliary roller;

5 d) a layer of silicone rubber of uniform thickness being provided on the positively structured circumferential surface of the auxiliary roller thus formed, and being vulcanized to produce an embossing matrix, and

10 e) the embossing matrix being pulled from the circumferential surface of the auxiliary roller, turned inside out, and adhered to a circumferential surface of an embossing roller, with the negatively structured embossing surface facing outward, thereby producing the embossing roller from silicone rubber with the negative form of a surface structure to be embossed.

15 5. Method according to Claim 4, wherein:

15 a) the smooth circumferential surface of the auxiliary roller includes a plastic disposed in such a way that the silicone rubber provided on this surface may be separated from the surface of the auxiliary roller after vulcanization.

6. Method according to Claim 5, wherein:

a) the plastic is nitrile butadiene rubber (NBR).